

Date: Monday, 2/19/2007 8:07:58 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 30756	
Estimate Number : 12714	
P.O. Number : <i>N/A</i>	Part Number : D353639
This Issue : 2/19/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3536 UNDER REVIEW <i>Rev A</i> <i>07.02.19</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL/MED FAB	Drawing Revision : U/R
Previous Run :	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 2/26/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i> <i>07.02.19</i>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.7911 sf(s)/Unit Total : 9.4928 sf(s)
 NEOPRENE SHEET 0.063
 Batch: *M 103104*

SAD 07/03/10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3536
 Dwg Rev: *A*
 Prog Rev: *A*

2-Deburr if necessary

SAD 07/03/10

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/10

(12)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/03/12 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

[Signature] *07/03/13 (12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PA Date: 07/03/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 30756

Part Number: D353639

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

FD 07/03/14

Job Completion



U 07-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

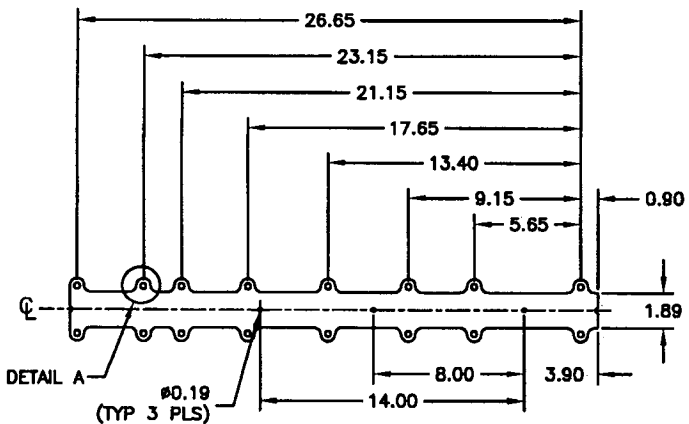
NOTE: Date & initial all entries

DART

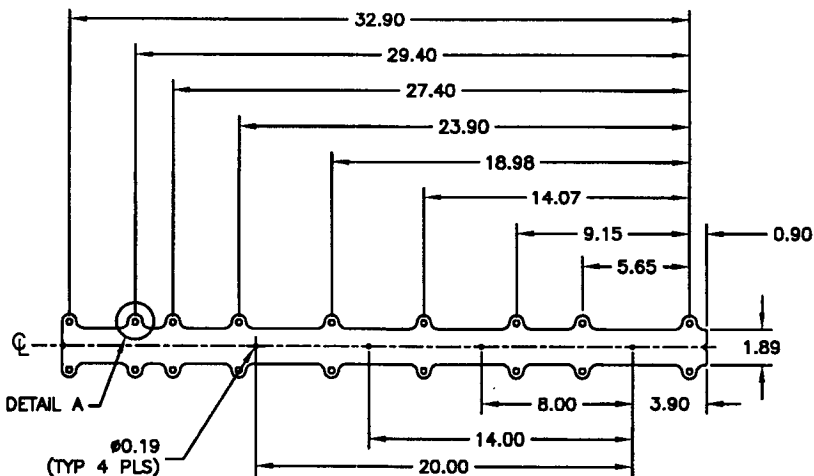
RELEASED

09.02.12-1

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10



D3536-11 GASKET



D3536-13 GASKET

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WORK ORDER
NO. 30750

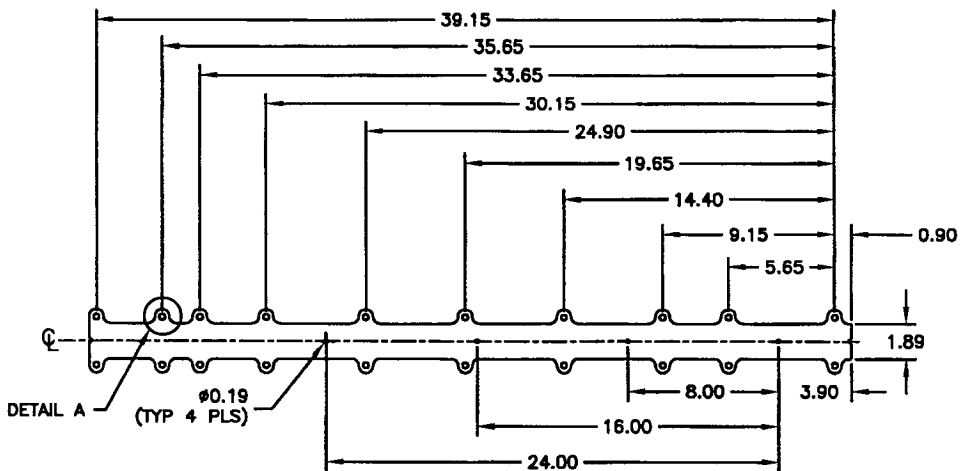
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

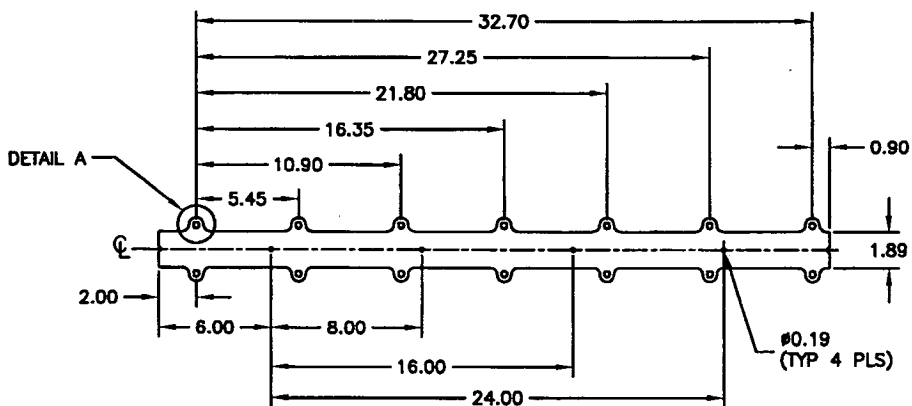
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DATE	06.10.25	TITLE	GASKET	REV. A	SHEET 2 OF 6
				SCALE	1:10

07.02.12 #



D3536-15 GASKET



D3536-21 GASKET

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NOTES

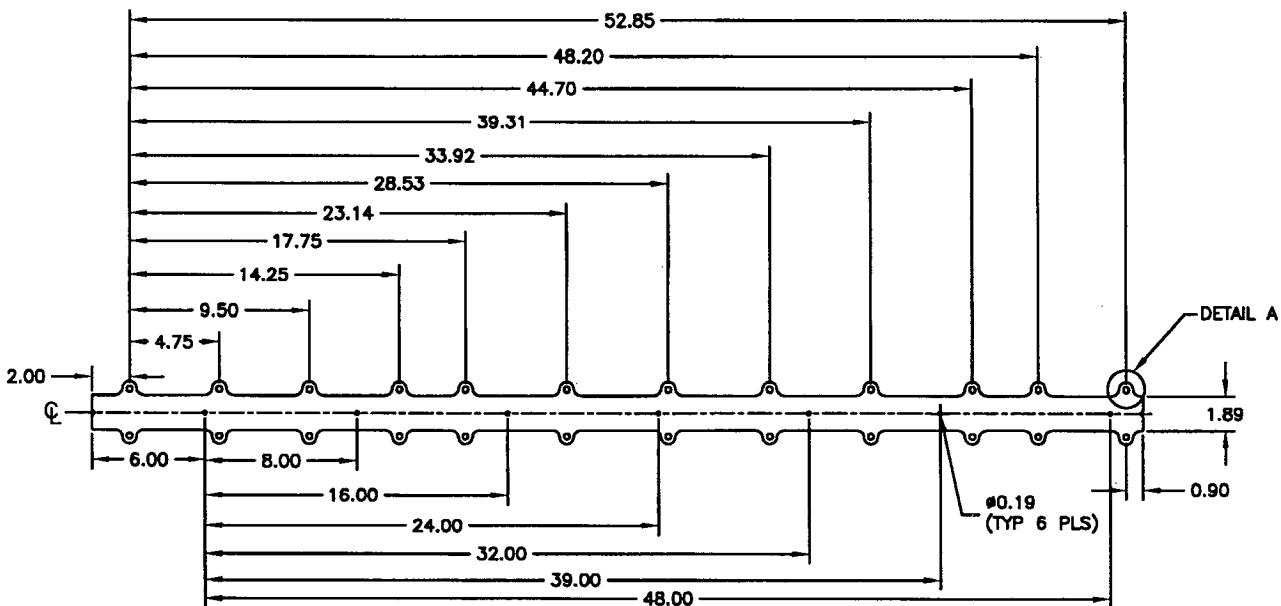
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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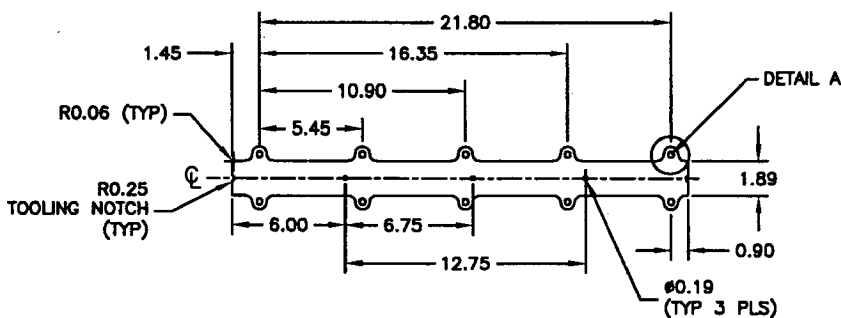
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DATE 06.10.25		TITLE GASKET
		REV. A SHEET 3 OF 6 SCALE 1:10

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D3536-23 GASKET



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 7) SEE PAGE 6 FOR DETAILS AND SECTION

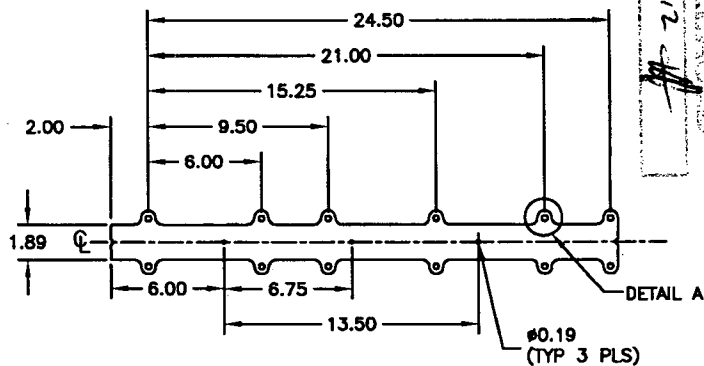
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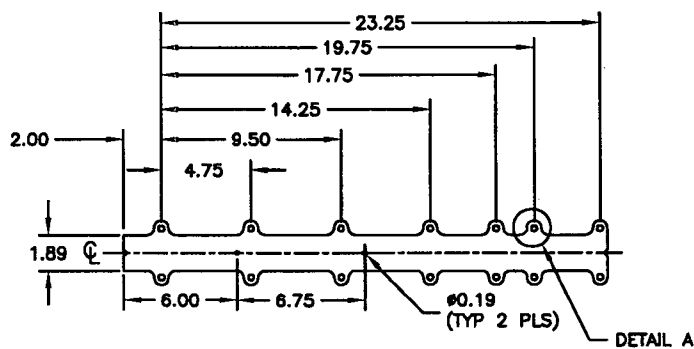
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DATE	06.10.25	TITLE	GASKET	REV. A
				SHEET 4 OF 6
				SCALE
				1:10

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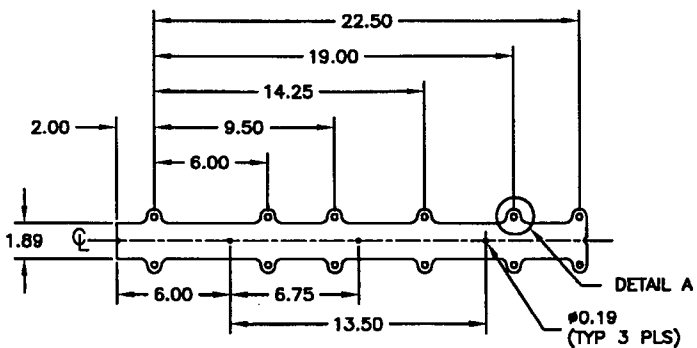
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

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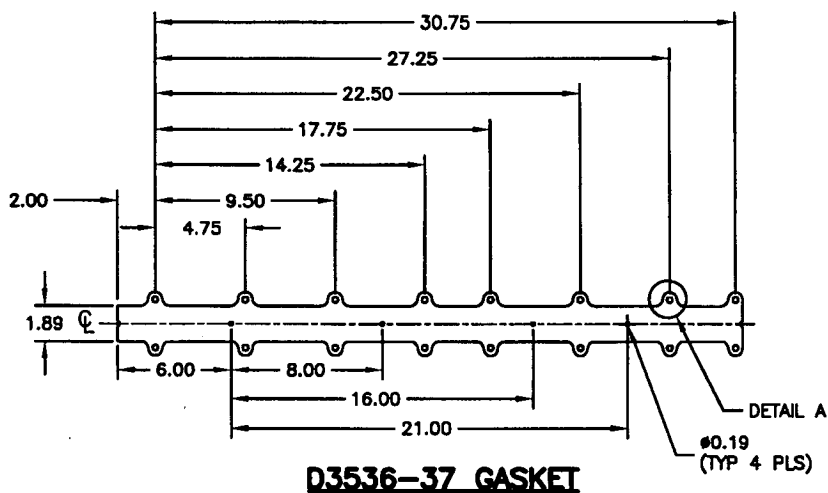
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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WORK ORDER
NO. 30750

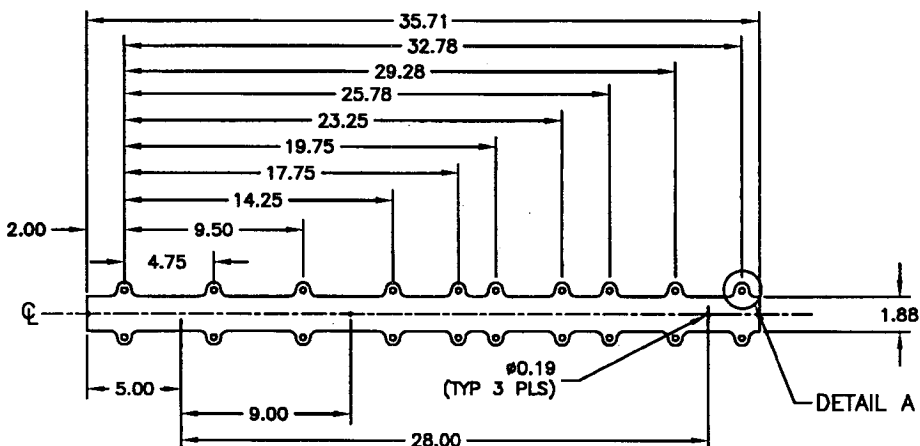
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 5 OF 6
		SCALE	1:10	

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PH



D3536-37 GASKET



D3536-39 GASKET

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NO. 20756

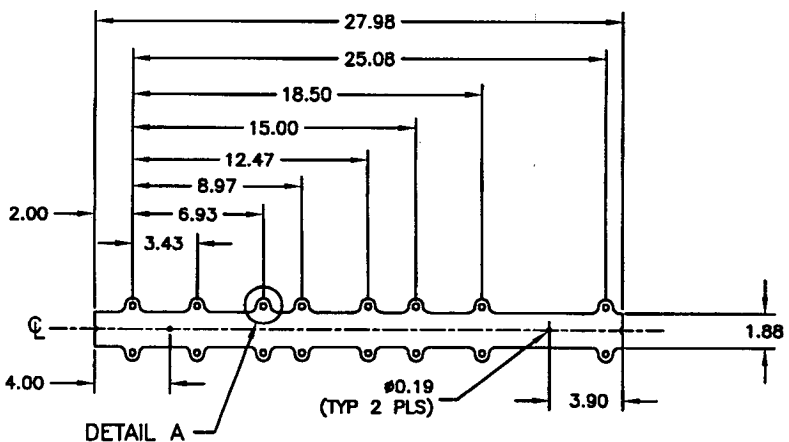
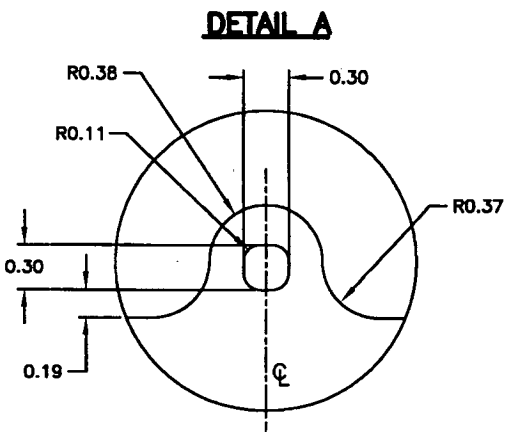
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 6 OF 6
			SCALE 1:10



D3536-41 GASKET

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WORK ORDER
NO. 30754

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

DART AEROSPACE LTD		Work Order: 30756
Description: Gasket		Part Number: D3536-39
Inspection Dwg: A	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/- 0.030	35.71	/		M-T	
32.78	+/- 0.030	32.75	/		M-T	
29.28	+/- 0.030	29.25	/		M-T	
25.78	+/- 0.030	25.75	/		M-T	
23.25	+/- 0.030	23.25	/		M-T	
19.75	+/- 0.030	19.75	/		M-T	
17.75	+/- 0.030	17.75	/		MT	
14.25	+/- 0.030	14.25	/		M-T	
9.50	+/- 0.030	9.480	-		Vern	
4.75	+/- 0.030	4.729	-		Vern	
1.88	+/- 0.030	1.89	-		Vern	
Ø0.19	+/- 0.030	Ø0.20	✓		Vern	
0.300	+/- 0.030	0.30	✓		Vern	
0.300	+/- 0.030	0.30	✓		Vern	
0.063	+/- 0.010	0.060	✓		Vern	

Measured by: SAM	Audited by: [Signature]	Prototype Approval:
Date: 07/03/10	Date: 07/03/12	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	